

# Work Order ID 69851



Page 1

Friday, May 20, 2011 10:39:44 AM

Item ID: D4038-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Fwd, RH

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *CL*

Date: 11/05/20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4038

D4038

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut Blank 7.125" long

0.00

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg & Folio FA880

Dwg Rev: *E*

Folio Rev: *AA*

Deburr

0.00

*CL 11/06/08*

*2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69851**

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Cust Item ID:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

JL 11/06/08

2

0



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

B.A 11/06/08

2

0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2X 0 M-11/06/09

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Revision ID:

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Item Name: Angle, Fwd, RH

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

2 BL 11-6-9

160 Identify as per dwg &amp; Stock Location: GA 0.00



Packaging Memo

0.00

Packaging

w/o  
69848 (20)

EP 11/06/09 (2)

170 QC21- Final Inspection - Work Order Release 0.00



QC Memo

0.00

Quality Control

w/o 11/06/09  
mf  
11-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Friday, May 20, 2011 10:39:42 AM

Work Order ID: 69851



Parent Item: D4038-2



Parent Item Name: Angle, Fwd, RH



Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	21.2845	0.7	1.473684			
 													
6061T6 ANGLE 4.00 x 4.00 x .250													

Location

Loc Qty

Loc Code

MAT006

20

→ 117285

20

MAT007

1.2845

114507

1.2845

1.473

on 11/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 69851
<b>Description:</b> Angle Swd, R-H		<b>Part Number:</b> D4038-2
<b>Inspection Dwg:</b> D4038 Rev: E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+ .030	3.995	/		Vern JL-3	
3.45	+ .030	3.452	/			
1.25	+ .030	.250	/			
.250	+ .010	.247	/			
1.25	+ .030	1.250	/			
1.25	+ .030	1.245	/			
2.877	+ .010	2.877	/		HG	
.581	+ .010	.581	/			
.669	+ .010	.669	/		HG	
.706	+ .010	.706	/		HG	
.500	+ .010	.500	/			
2.00	+ .030	2.00	/			
.563	+ .010	.563	/		HG	
φ.316	+ .006	.316	/			
φ.189	+ .005	.190	/			
1.13	+ .030	.130	/			
1.00	+ .030	1.00	/			
1.063	+ .010	1.063	/		HG	
1.563	+ .010	1.563	/			
1.19	+ .030	1.19	/			
1.00	+ .030	1.00	/			
2.125	+ .010	2.125	/			
.911	+ .010	.910	/			

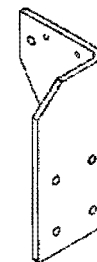
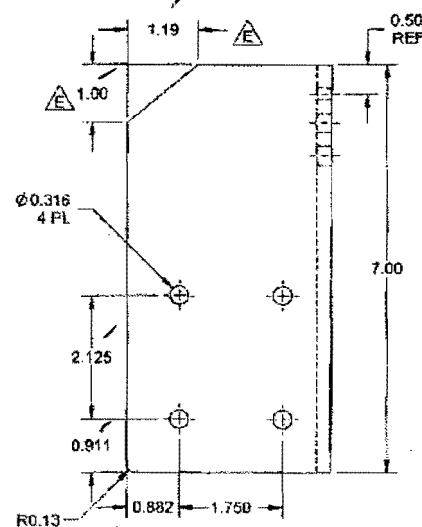
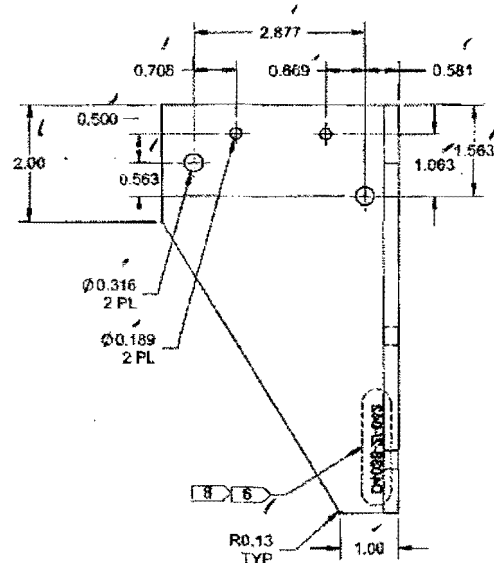
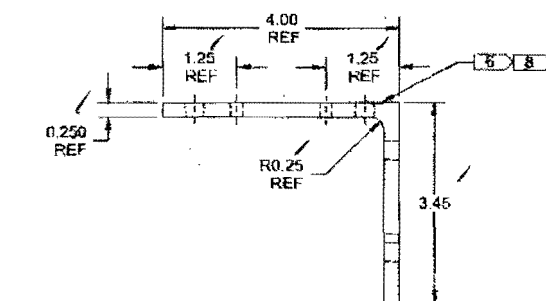
<b>Measured by:</b> JL	<b>Audited by:</b> B.A	<b>Prototype Approval:</b>
<b>Date:</b> 11/06/08	<b>Date:</b> 11/06/08	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	










**D4038-2 ANGLE, FWD, RH**

**NOTES:**

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250  
PER AMS-QQ-A-200/8  
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX  
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 4 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.04.11	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS CONFIDENTIAL, UNCLASSIFIED, OR SECRET INFORMATION THAT IS NOT TO BE RELEASED FOR ANY PURPOSE, IN ANY FORM OR BY ANY MEANS, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

69851

RELEASED  
R 2011-04-22

